

Date: Friday, 2/23/2007 8:32:20 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 30898		
Estimate Number	: 10709		
P.O. Number	: N/A	Part Number	: D32101
This Issue	: 2/23/2007 S.O. No. : N/A	Drawing Number	: D3210 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 29552	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 3/14/2007 Qty: 8 Um: Each
Checked & Approved By	: <u>[Signature] 07.02.23</u>		
Comment	: Est Rev: A New Issue 05-11-17 JLM Est Rev: B Now On Waterjet 06-10-24 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S080	2024-T3 .080 sheet
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Comment: Qty.: 2.6177 sf(s)/Unit Total : 20.9412 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.080" thick

(M2024T3S.080) Identify as D3210-1 15.7058

Batch: ~~M102838~~ M102838 m18481 x2 5.2354

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3210

Dwg Rev: BProg Rev: B

SAD 07/02/26 (8)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/02/26

8

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAD 07/02/27

(8)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr

m1 07/02/07

x8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/12

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:32:20 AM  
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Drawing Name: DOUBLER

Job Number: 30898

Part Number: D32101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(8x)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L/JD 7-3-8

7.0

POWDER COATING

POWDER COATING



M100700



(8x)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-L

07/03/09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Bayb368 8

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Bayb368 8

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/12

Job Completion



U 07-03-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



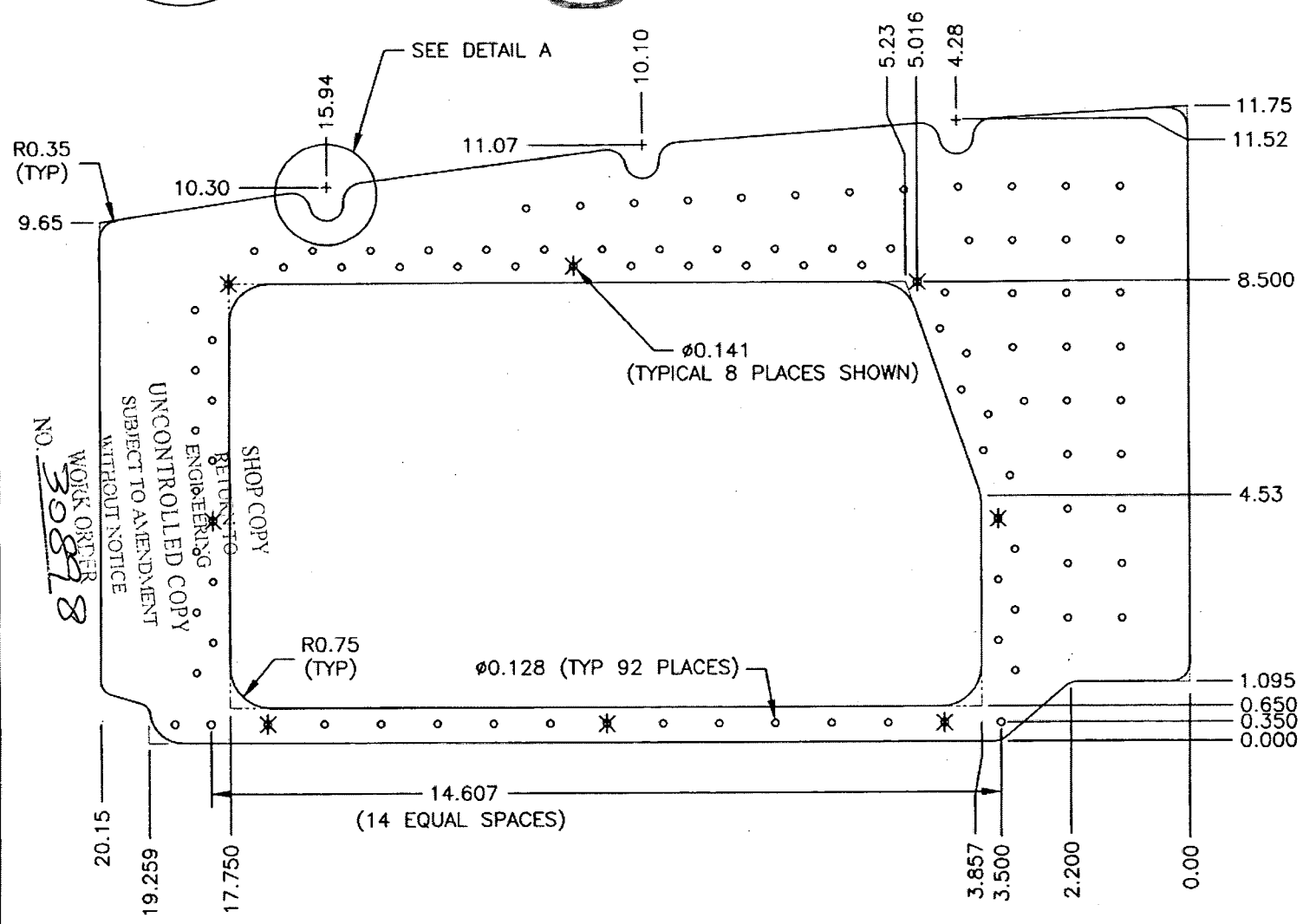
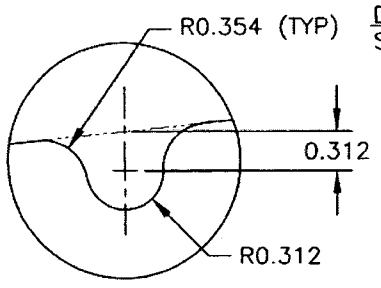


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
03.09.03	03.09.03	NEW ISSUE	
CHECKED	APPROVED	DRAWING NO.	REV. A
03.09.03	03.09.03	D3210	SHEET 1 OF 1
DATE	TITLE	DOUBLER	SCALE
03.09.03	DOUBLER	NEW ISSUE	1:3

D3210-1 DOUBLER  
MAKE PER DRAWING FILE "D3210-A1.DWG"  
CHECK PER TEMPLATE D3210-1T1  
DIMENSIONS SHOWN FOR REFERENCE ONLY  
MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER  
DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
03.09.03

DETAIL A  
SCALE 2:3



SHOP COPY  
RETURN TO  
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WITHOUT NOTICE

WORK ORDER  
NO. 30898